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D4016-3
Job Sheet 196392



Part No: D4016-3

Job Qty: 20 pcs

Part Name: Hinge Half, Lid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 2 IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as per dwg REV.A
DD 10.02.22 verified by:EC

Ship Via:

BNI of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	7/12/19	7/12/19	0.00	0.77	Bandsaw - 1		
110	HAAS 4 Axis - B4B	20 pcs	7/12/19	7/12/19	0.09	7.35	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs	7/12/19	7/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		

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160 Packaging 3-1 - Stock - B4B 20 pcs

7/12/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

170 QC 21 - SA

20 pcs

7/12/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - CUT BLANK as per folio

Descriptions: 110 - (HAAS CNC Vertical Machine), MACHINE AS PER FOLIO FA874 AND DWG

130 - (QC8- Inspect parts - second check)

160 - (Identify as per dwg & Stock Location: _____), LOCATION: WA004-6

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B1.000X1.000	304 Bar 1.00 X 1.00	1.6000 ft (.08 ea)	100-Bandsaw - 1	5190197

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304B1.000X1.000	2	3	0

MAT
used
3-500

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Lid	0.880Inches $\pm$ 0.030	0.910 0.850	.880	
2	Hinge Half, Lid	0.130Inches $\pm$ 0.030	0.160 0.100	.129	
3	Hinge Half, Lid	0.250Inches $\pm$ 0.010	0.260 0.240	.250	
4	Hinge Half, Lid	0.030Inches $\pm$ 0.030	0.060 0.000	.03	Radius
5	Hinge Half, Lid	0.130Inches $\pm$ 0.030	0.160 0.100	.120	
6	Hinge Half, Lid	0.500Inches $\pm$ 0.030	0.530 0.470	.499	
7	Hinge Half, Lid	0.630Inches $\pm$ 0.030	0.660 0.600	.631	
8	Hinge Half, Lid	0.563Inches $\pm$ 0.010	0.573 0.553	.563	
9	Hinge Half, Lid	0.257Inches + 0.006 - 0.001	0.263 0.256	.257	Diameter

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DAS
52
89

19/06/22

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					